

Date: Friday, 22/05/2009 9:57:19 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : PANEL, POST RH, UPPER
<b>Job Number</b> : 48131	
<b>Estimate Number</b> : 13944	
<b>P.O. Number</b> :	<b>Part Number</b> : D39472
<b>This Issue</b> : 22/05/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3947-2
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : IN0001
<b>First Issue</b> : // <b>Type</b> : R&D THERMOFORMING	<b>Drawing Revision</b> : A PROTOTYPE 09.05.21
<b>Previous Run</b> :	<b>Material</b> : MLEXS093F600607
<b>Written By</b> :	<b>Due Date</b> : 22/05/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : JUD 09.05.22	
<b>Comment</b> : Est. Rev. A New Issue 09/05/22 DL	

## Additional Product

# PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET
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**Comment:** Qty.: 3.5385 sf(s)/Unit Total : 3.5385 sf(s)  
 GE PLASTICS LEXAN SHEET

M107574

CP  
09.05.22

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/05/22

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/05/22 (X1)

4.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3947-2 and folio (FTA 3946-1 Prototype) using tool DT 9483

Dwg. Rev. A

Folio Rev. A

BB 09/05/22 (X1)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/05/22 (X1)

**ENGINEERING  
 APPROVAL**



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Drawing Name: PANEL, POST RH, UPPER

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Part Number: D39472

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



(X1)

Comment: SECOND CHECK

DL 09.05.22

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



(X1)

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

DL 09.05.22

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



(X1)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

ENGINEERING  
APPROVAL

DL 09.05.22

9.0

QC5

INSPECT WORK TO CURRENT STEP



DL 09.05.22

Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



DL 09.05.22

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

FOR ENGINEERING USE ONLY

N/A ENG USE ONLY

11.0

QC21

FINAL INSPECTION/W/O RELEASE



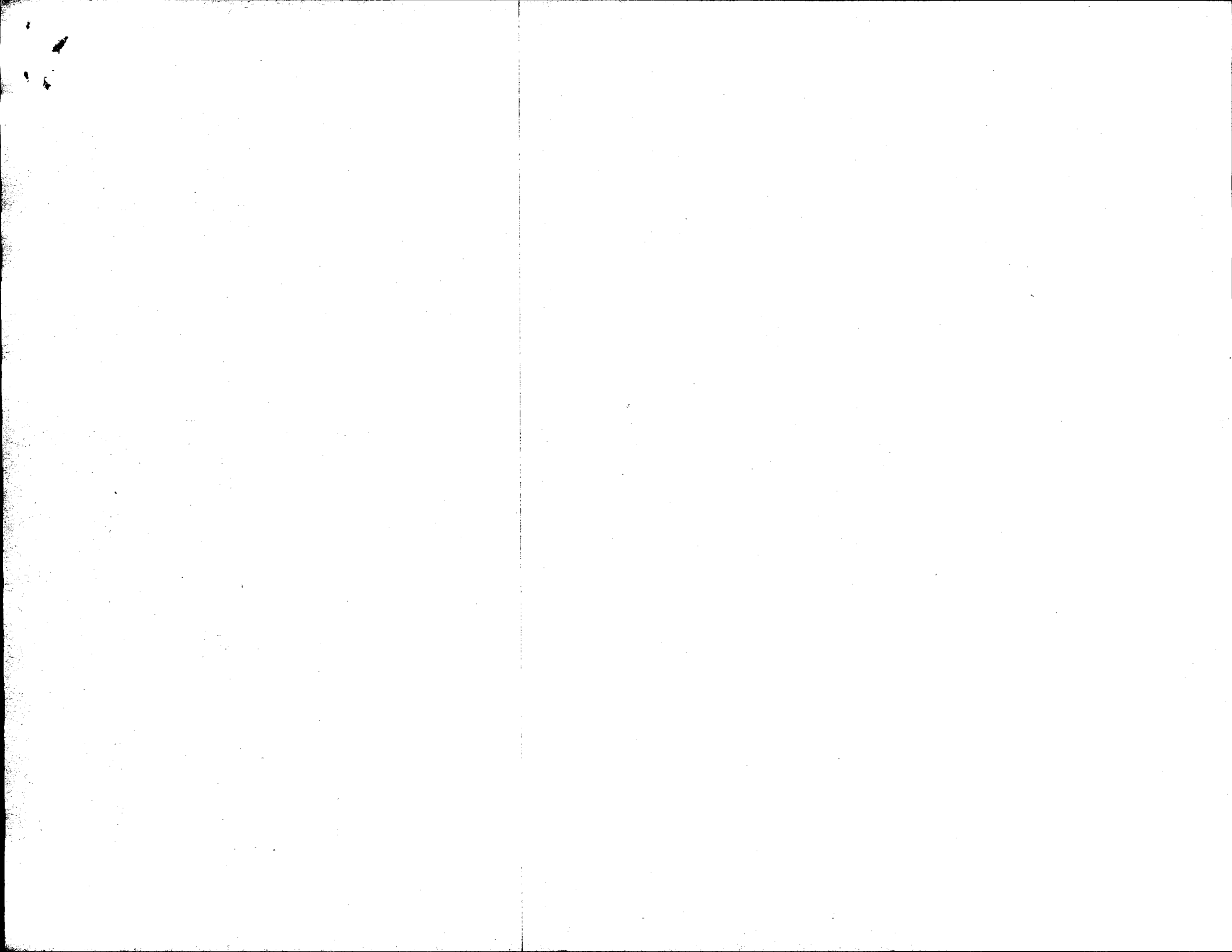
Comment: FINAL INSPECTION/W/O RELEASE

DL 09.05.22 Prototype

Job Completion



002807A MF  
09-06-04



DART AEROSPACE LTD	Work Order: 48131
Description:	Part Number: D3947-2
Inspection Dwg: D3947-2 Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/05/22

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
27.4		27.4	✓			
3.8		3.8	✓			
.6		.6	✓			
.4		.4	✓			
1.0		1.0	✓			
0.050"		0.063	✓			
0.075"		0.084	✓			

Measured by: Bk

Date: 09.05.22

Audited by: BB

Date: 09/05/22

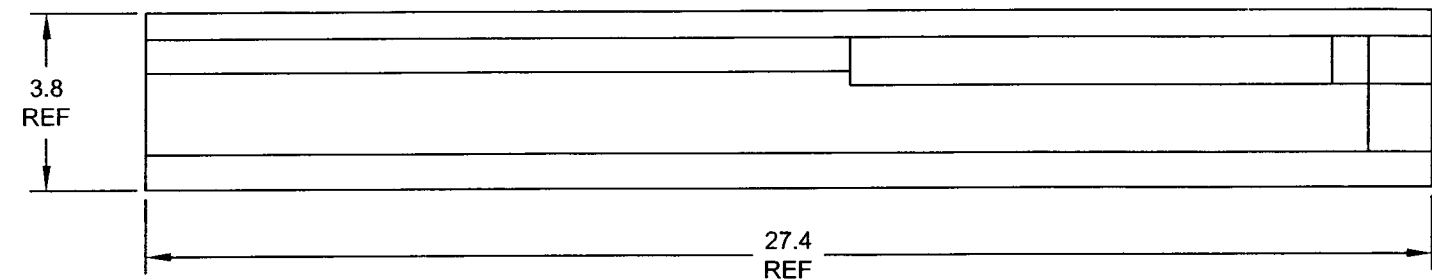
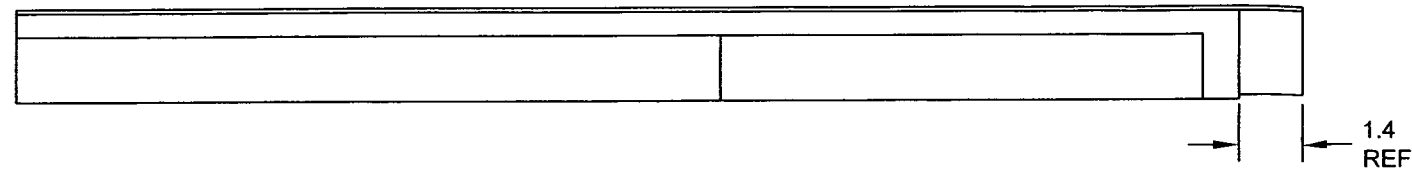
Prototype Approval: CP

Date: 05/05/22

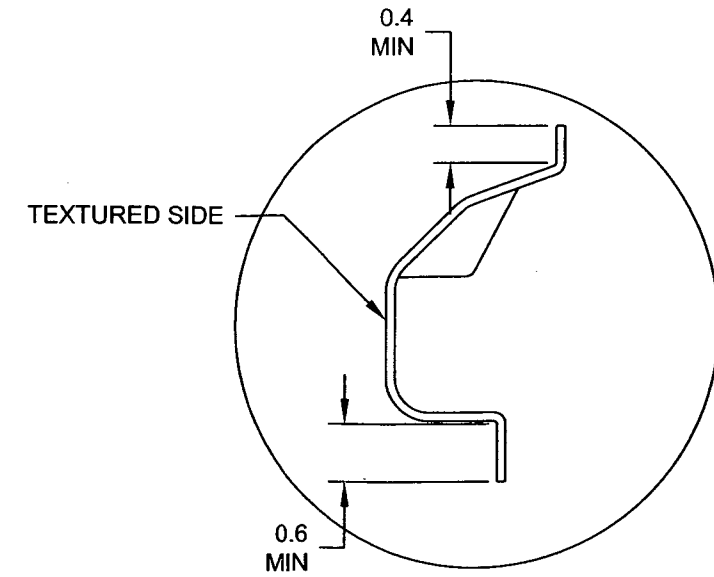
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

8 7 6 5 4 3 2 1

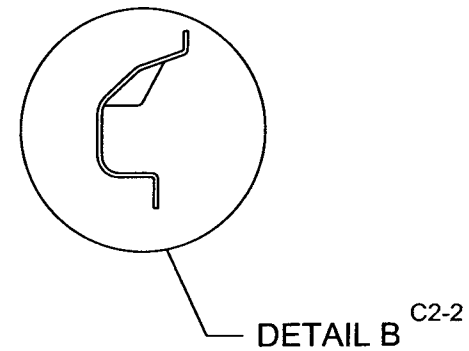
**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
*UP* 09.05.21



**D3947-2 PANEL, RH**



**DETAIL B<sup>B3-2</sup>**



**NOTES:**

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK  
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-2" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.47 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9483 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.075" ELSEWHERE

DESIGN	<i>UP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>PH</i>		
CHECKED	<i>UP</i>	DRAWING NO.	REV. A
MFG. APPR.		D3947	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		PANEL (AS 350/355)	NTS
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